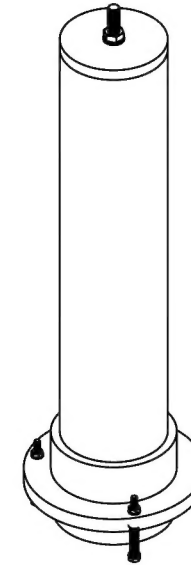
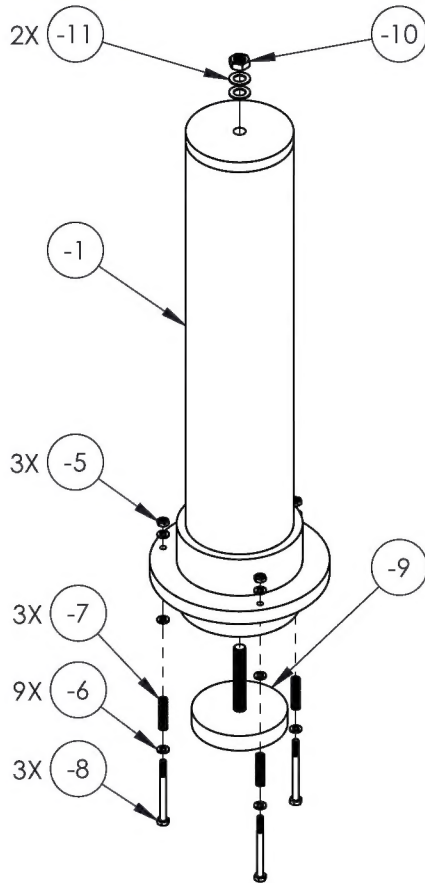


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0173	REDRAWN IN SOLIDWORKS. -4 CH'D DIM WAS 4.055 IS 4.13. -7 CH'D B/O INFO WAS MS24585 IS MCMaster-CARR #9434K77. -9A ADDED TO BOM. -12 CH'D B/O INFO WAS AN8-33A IS MCMaster-CARR #92620A751.	10/13/2014	DPD	GE

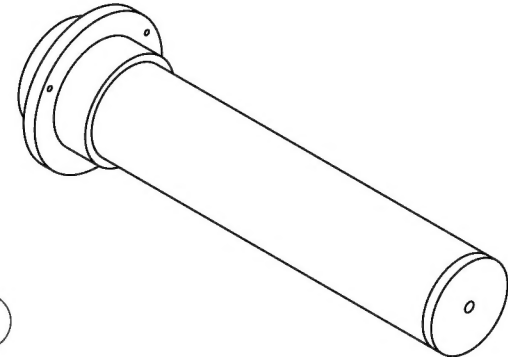
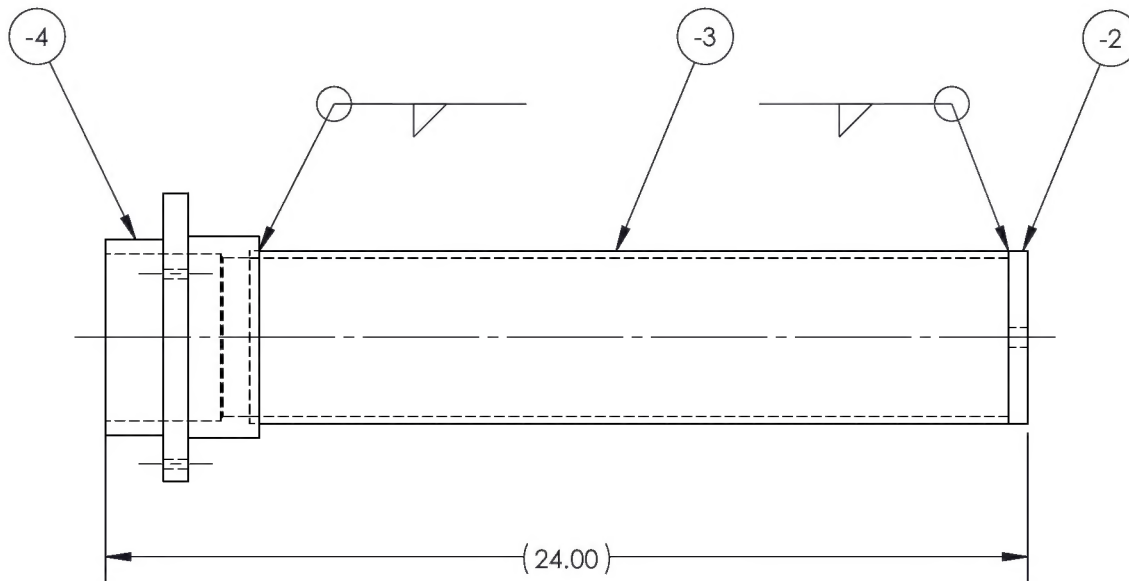
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	PRESSING TOOL WELDMENT			2
	1		-2		END PLATE	6061	Ø4.5 X 1/2	3
	1		-3		TUBE	6061	Ø4-1/2 X .190 WALL X 19-7/8	4
	1		-4		COLLAR	6061	Ø8 X 4-1/8	5
		B/O	-5	3	LOCK NUT	STEEL	1/4-28 NAS679A4	1
		B/O	-6	9	WASHER	STEEL	Ø1/4 AN960-416	1
		B/O	-7	3	SPRING	STEEL	Ø.36 X Ø.038 WIRE X 1-1/2 MCMaster-CARR #9434K77	1
		B/O	-8	3	BOLT	STEEL	1/4-28 X 3 AN4-30	1
X			-9	1	PLATE WELDMENT			6
1			-9A		PLATE	304 S.S.	Ø4 X 7/8	7
		B/O	-10	1	HEX NUT	STEEL	1/2-20 AN315-8	1
		B/O	-11	2	WASHER	STEEL	Ø1/2 AN960-816	1
1		B/O	-12		BOLT	STEEL	1/2-20 X 3-1/2 MCMaster-CARR #92620A751	6
ASSY -9	ASSY -1							



TITLE		M/R MAST BEARING WORK AID	
DWG NO.		RBT18642	
REV		5	
MAT'L		DRAWN BY: DUERFELDT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>J Gilbert</i>	
.XXX ± .005		HEAT TREAT	
.XX ± .01		FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45°		USED ON MODEL	
OR .015R		BELL 204, 212	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE 1:8		DATE 10/10/2014	
		SHEET 1 OF 7	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

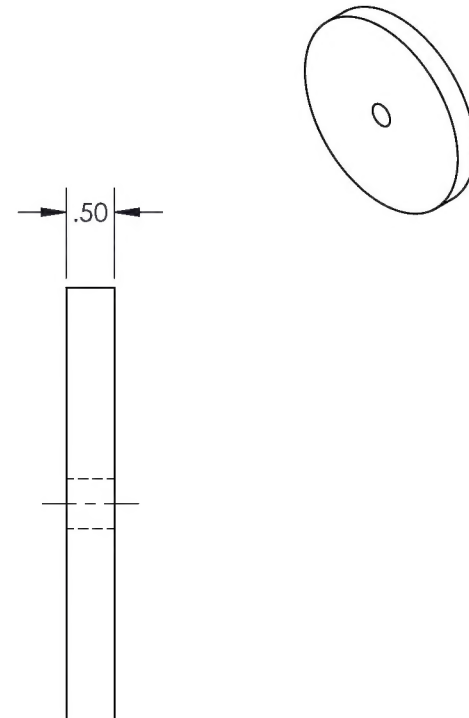
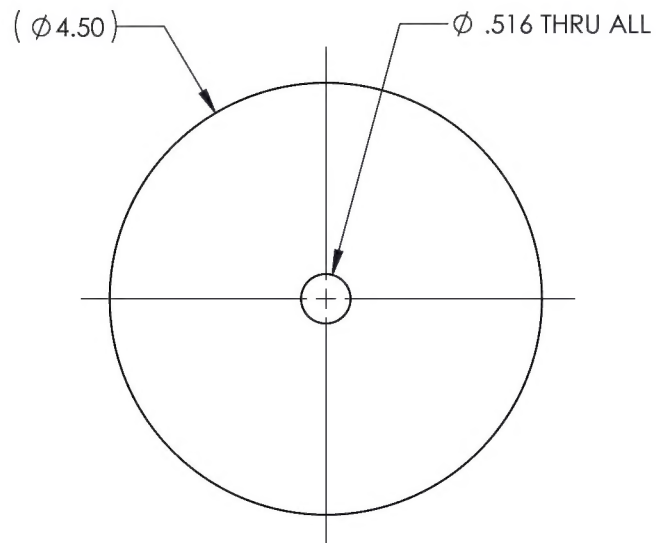


(-1)
PRESSING TOOL WELDMENT

DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-1	REV 5
MAT'L	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	CLEAR ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 204, 212
SCALE 1:5	DATE 10/10/2014
	SHEET 2 OF 7

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



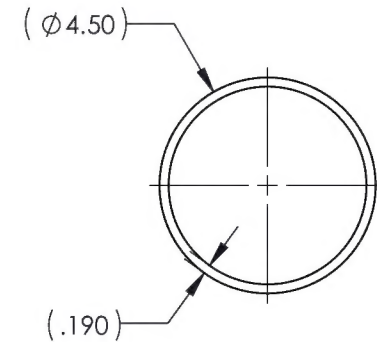
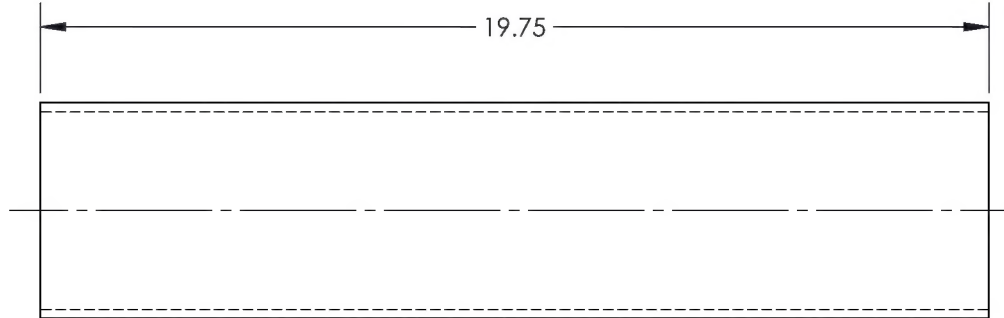
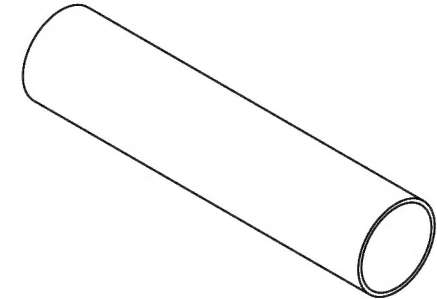
(-2)

END PLATE

DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-2	REV 5
MAT'L 6061	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH SEE -1 WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204, 212
SCALE 1:2	DATE 10/10/2014
SHEET 3 OF 7	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

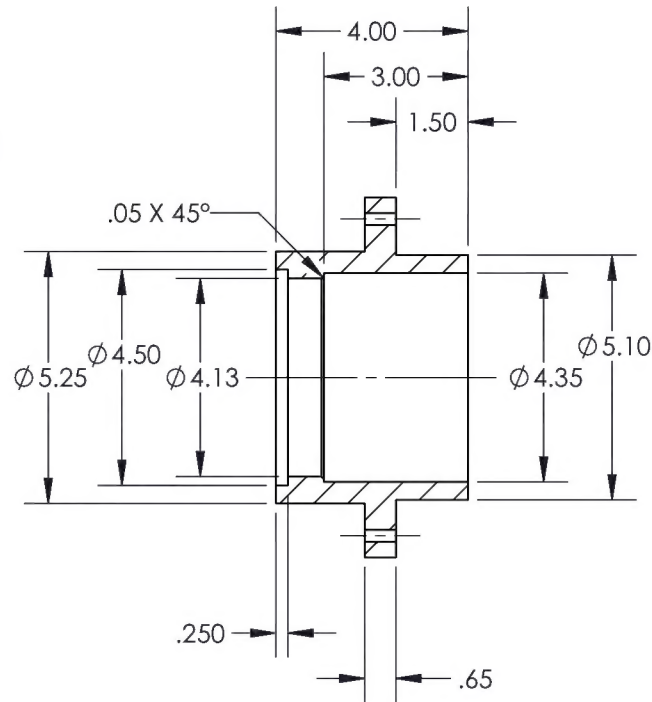
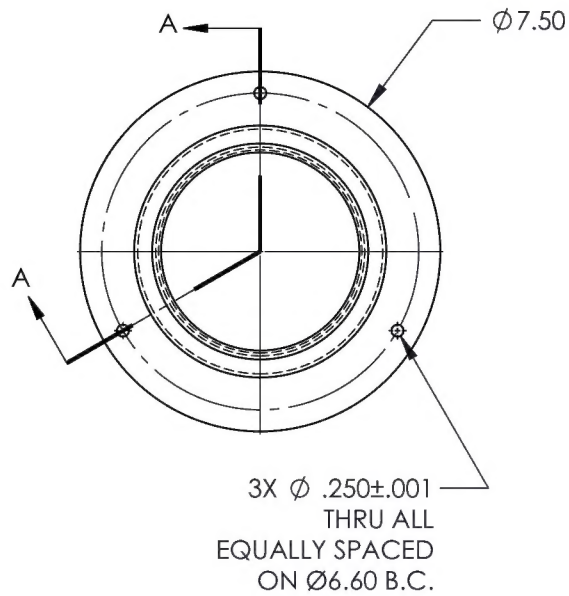


(-3)
TUBE

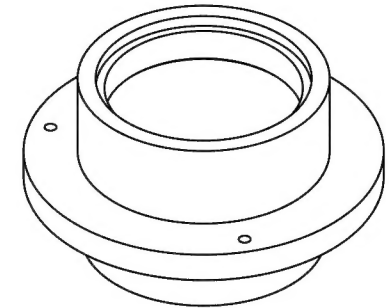
DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-3	REV 5
MAT'L 6061	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH SEE -1 WELDMENT
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 204, 212
SCALE 1:4	DATE 10/10/2014
	SHEET 4 OF 7

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	14-0173	•4 CH'D DIM WAS 4.055 IS 4.13.	10/13/2014	DPD	GE



SECTION A-A

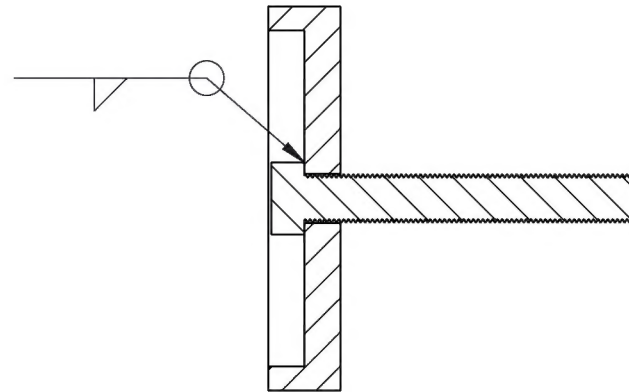
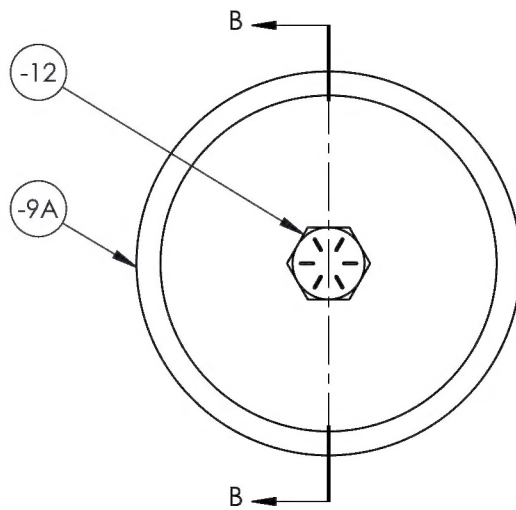


(-4)
COLLAR

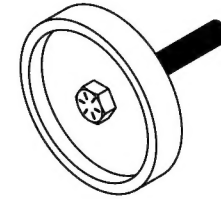
DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-4	REV 5
MAT'L 6061	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH SEE -1 WELDMENT
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204, 212
SCALE 1:4	DATE 10/10/2014
SHEET 5 OF 7	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION B-B

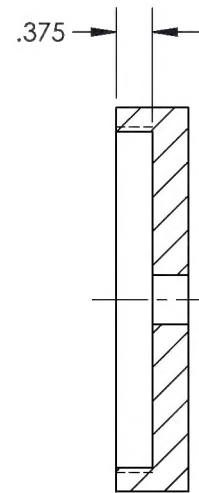
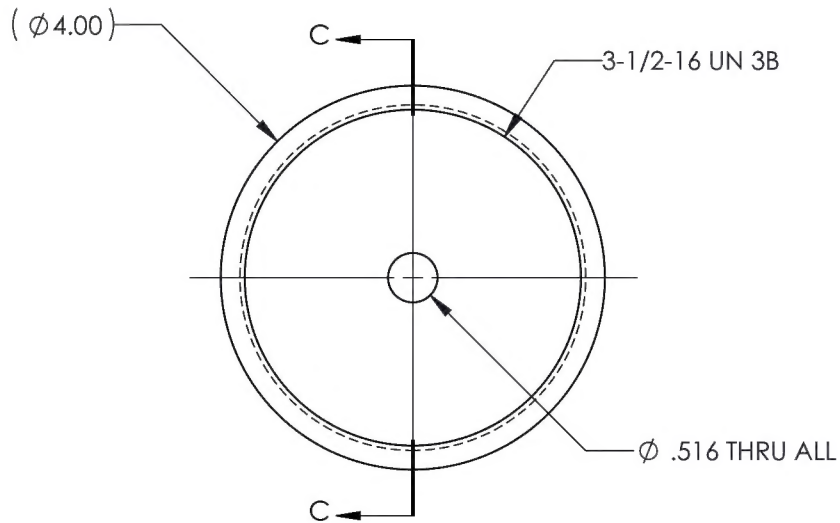


(-9)
PLATE WELDMENT

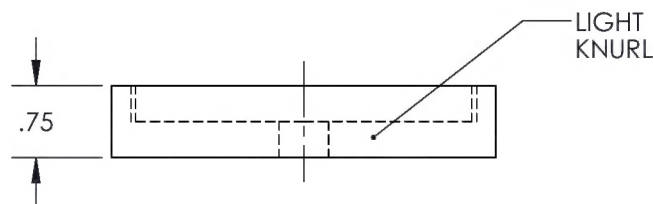
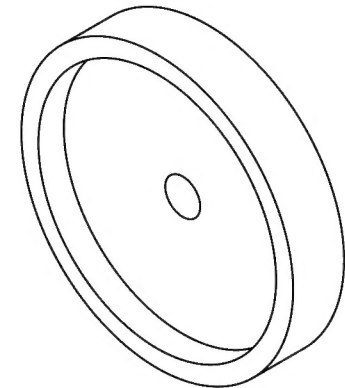
DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-9	REV 5
MAT'L	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	BELL 204, 212
SCALE 1:2	DATE 10/10/2014
	SHEET 6 OF 7

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION C-C



(-9A)

PLATE

DART AEROSPACE	
TITLE M/R MAST BEARING WORK AID	
DWG NO. RBT18642-9A	REV 5
MAT'L 304 S.S.	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>J Gilbert</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH SEE -9 WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	BELL 204, 212
SCALE 1:2	DATE 10/10/2014
SHEET 7 OF 7	